

Date: Tuesday, 7/10/2007 1:05:51 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD	
Job Number : 33455		
Estimate Number : 12785		
P.O. Number : N/A	Part Number : D356411	
This Issue : 7/10/2007 S.O. No. : N/A	Drawing Number : D3564 REVC	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C	
Previous Run : N/A	Material : N/A	
Written By : [Signature]	Due Date : 7/17/2007 Qty: 20 Um: Each	
Checked & Approved By : [Signature] 07.07.10		
Comment : Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM		
<b>Additional Product</b>		
Job Number: [Barcode]		
Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
	[Barcode]	[Barcode]
Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <del>N/A</del> M104725 IB 07-07-11		
2.0	WATER JET	FLOW WATER JET
	[Barcode]	[Barcode]
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: C Prog Rev: C  2-Deburr if necessary -> SAD 07/07/13 (20) IB 07-07-11		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	[Barcode]	[Barcode]
Comment: INSPECT PARTS AS THEY COME OFF MACHINE IB 07-07-11		
4.0	QC8	SECOND CHECK
	[Barcode]	[Barcode]
Comment: SECOND CHECK Counted 50 07/07/12 (x20)		
5.0	BRAKE NC	NC BRAKE
	[Barcode]	[Barcode]
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155 SAD 07/07/17 (20)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 02/07/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33455

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

E 07/07/17 (X20)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M104463

M105058

88 07/07/24 (X20)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-25 (20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

E 07/07/05 (X20)

10.0

POWDER COATING

POWDER COATING



M 104 846



(20)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/F 07-07-26

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m.p. 07/07/26 (20X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FP-14

m.p.

07/07/26 (20X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

E 07/07/27 (20)

Job Completion



M 07-07-27

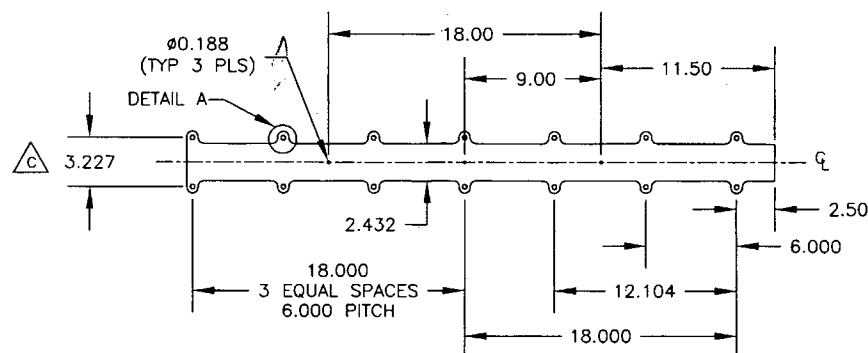
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

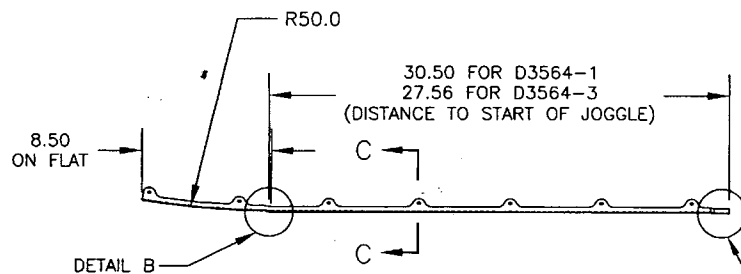
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

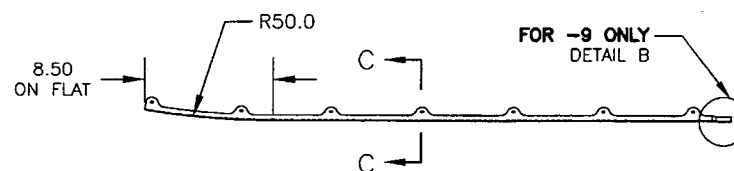
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**



**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

FOR -1 ONLY  
DETAIL B

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

**RELEASED**  
07-06-28

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

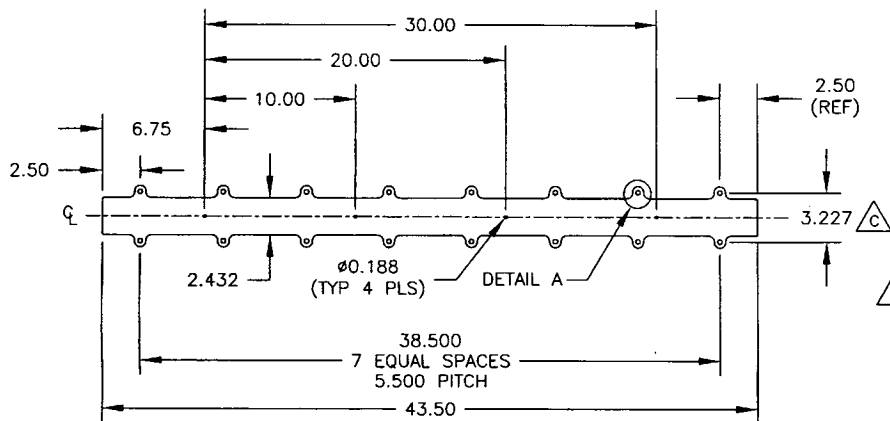
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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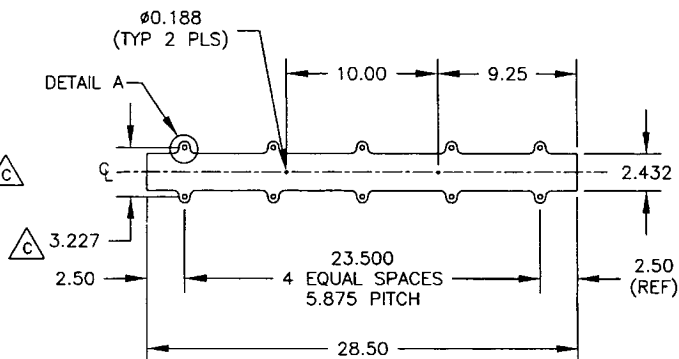
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 SCALE 1:8

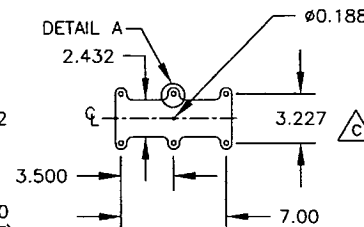
NO. 33455  
WORK ORDER  
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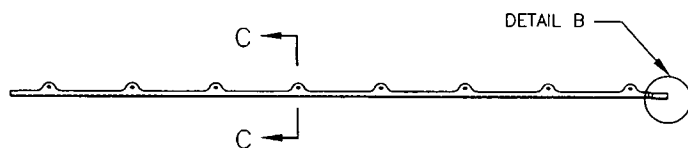
**D3564-5F FLAT PATTERN**



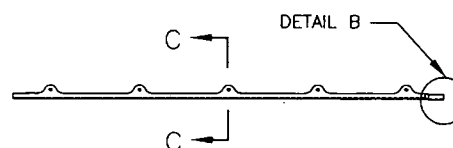
**D3564-7F FLAT PATTERN**



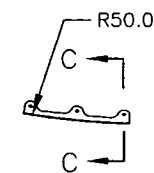
**D3564-13F FLAT PATTERN**



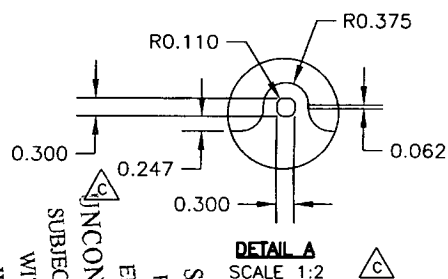
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



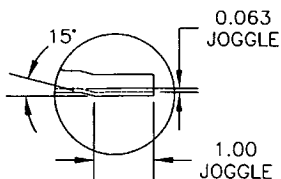
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

**RELEASED**  
07.04.17

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CHECKED	#	APPROVED	#	DRAWING NO. D3564	REV. C SHEET 2 OF 2
DATE	07.04.17	TITLE	WEARSHOE	SCALE	1:8

